



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200
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D3570-3

Job Sheet 197624



Part No: D3570-3

Job Qty: 8 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 11/9/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1,4

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		11/9/19	0.17	0.53	Waterjet - Flow		12/19/10/16
110	QC 2	8 pcs		11/9/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		12/19/10/16
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120	QC 8	8 pcs	11/9/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	OCT 17 2019
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
130	Small Fab - 2 - B4B	8 pcs	11/9/19	0.00 3.16	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	OCT 18 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
140	QC 5	8 pcs	11/9/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	OCT 18 2019
					QC 5 - 61	
					QC 5 - 81	
150	Handfinish - 1-1 Chemical- B4B	8 pcs	11/9/19	0.00 0.37	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	OCT 18 2019

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				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160	Powdercoat - 3 Grey Sand - B4B	8 pcs	11/9/19	0.00 0.06	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
170	QC 3	8 pcs	11/9/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
180	Packaging 3-1 - Stock - B4B	8 pcs	11/9/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B

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	Packaging 3 - 3 - B4B			
	Packaging 3 - 4 - B4B			
	Packaging 3 - 5 - B4B			
	Packaging 3 - 6 - B4B			
	Packaging 3 - 7 - B4B			
	Packaging 3 - 8 - B4B			
	Packaging 3 - 9 - B4B			
	Packaging 3 - 10 - B4B			
	Packaging 3 - 11 - B4B			
	Packaging 3 - 12 - B4B			
	Packaging 3 - 13 - B4B			
	Packaging 3 - 14 - B4B			
	Packaging 3 - 15 - B4B			
	Packaging 3 - 16 - B4B			
	Packaging 3 - 17 - B4B			
	Packaging 3 - 18 - B4B			
	Packaging 3 - 19 - B4B			
	Packaging 3 - 20 - B4B			
	Packaging 3 - 21 - B4B			
	Packaging 3 - 22 - B4B			
	Packaging 3 - 23 - B4B	PC GA121		
	Packaging 3 - 24 - B4B			
	Packaging 3 - 25 - B4B			
	Packaging 3 - 26 - B4B			
	Packaging 3 - 27 - B4B			
	Packaging 3 - 28 - B4B			
	Packaging 3 - 29 - B4B			
	Packaging 3 - 30 - B4B			
	Packaging 3 - 31 - B4B			
	Packaging 3 - 32 - B4B			
	Packaging 3 - 33 - B4B			
	Packaging 3 - 34 - B4B			
	Packaging 3 - 35 - B4B			
	Packaging 3 - 36 - B4B	DAG 21 9.38		
	190 QC 21 - SA	8 pcs	11/9/19 0.00 0.00	
		QC 21 - SA - 21		
	QC 21 - SA - 70			
	QC 21 - SA - 53			
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location:_____) 190 - (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.6960 sf (.087 ea)	100-Waterjet - Flow - 1	SIL7937
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.125	1	6	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	197624
Description: Bracket		Part Number:	D3570-3
Inspection Dwg: D3570 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	Ø.208	1		V.D. 0.02	
0.435	+/-0.010	.440	1		Top	
0.658	+/-0.010	.659	1			
1.841	+/-0.010	1.845	1			
2.064	+/-0.010	2.066	1			
2.38	+/-0.030	2.38	1			
0.359	+/-0.010	.361	1			
0.557	+/-0.010	.558	1			
1.943	+/-0.010	1.945	1			
2.141	+/-0.010	2.140	1			
5.25	+/-0.030	5.25	1			
1.00	+/-0.030	1.006	1			
0.125	+/-0.010	.121	1			

Measured by:	me	Audited by:	DAS 40	Prototype Approval:	N/A
Date:	19/10/16	Date:	OCT 17 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.09	New Issue	KJ	MA

Entered: JK Date: Nov 18/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7728

Route update only ☐

Job: <u>197624</u> Part No. <u>D3570-3</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date: <u>OCT 18 2019</u>		Sequence #: <u>130</u>		QTY Affected: <u>508 508</u>			MRB (QSI042) DAS 9 9-89 <u>19-10-31</u>																												
Description Work Order Deviation <u>hole off set</u> <u>2 parts</u>				Disposition <u>Scrap + destroy</u> <u>No replace</u>				Completed By <u>CB</u>																											
								Lead hand / Supervisor DAS 30 9-89 <u>OCT 18 2019</u>																											
								QC / QA Coordinator DAS 9 9-89 <u>19-10-31</u>																											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details: <u>Need better sig for this part</u>																																	